

Work Order ID 77760

December-21-11 9:03:03 AM

ASAP

77760

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

002
Non-Engraver

12 01 05 (6)

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

114514
118735

11.12.21 6 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77760

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

0.00

QC

Memo

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

0.00

QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

0.00

HandFinish

Memo

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 77760***77760***

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Item ID: D350-591-311

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

12.01.02 6 0

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod M114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

12.01.02 6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

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Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop ***NS2***

Start Date: 21/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC10- Inspect visual per QSI004- ground welds

0.00

190

0.00 8/12/01/02

QC

Memo

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

0.00 8/12/01/02

QC

Memo

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

0.00

HandFinish

Memo

Hand Finishing

6X4 m-1 12/01/02
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 77760

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December-21-11 9:03:03 AM

Item ID: D350-591-311 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long LH
 Start Date: 21/12/2011 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 29/12/2011 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

220

Powdercoat

Powder Coating

Memo

START TIME: 10:30

OVEN TEMPERATURE: 320 OF

FINISH TIME: 11:00

6X8 M/L 12/01/03

230	Wing Walk as per dwg QSI005 4.4 Batch 119094	0.00							
-----	--	------	--	--	--	--	--	--	--

230

HandFinish

Hand Finishing

Memo

0.00

6 PL 12-01-3.

240	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

240

QC

Quality Control

Memo

0.00

6 H/L 12/02/01
 counted & identified.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-311

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

12/1/4 SL (6)

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

12/1/5 SL (6)

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: 81

12/1/5 SL (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 77760***77760***

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December-21-11 9:03:03 AM

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step, Long LH
Start Date: 21/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 29/12/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

CK 12/01/06.

MF #12-01-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 77760

77760

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011 *D319410-011* Step Modification		Manufactured	No				Each	0.0000	**	6			
D3272-1 *D3272-1* Step		Manufactured	No			110	Each	0.0000	1	6		11.12.21	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				ST	-10				6				
				WA	10								
D3067-1 *D3067-1* End Plate		Manufactured	No			110	Each	67.0000	1	6		11.12.21	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				WA016	67								
				67582	2								
				68214	1								
				76179	64				6				
D3219-1 *D3219-1* Plate		Manufactured	No			110	Each	46.0000	2	12		11.12.21	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				WA016	46								
				73410	12								
				76226	34				12				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 2

Work Order ID: 77760

77760

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

D3066-1

Manufactured

No

180

Each

86.0000

2

12

D3066-1

Spacer

**

11.12.29LocationLoc QtyLoc Code

WA015

86

76180

86

12

MS20600-AD4W4

Purchased

No

180

Each

2,866.000

16

96

MS20600-AD4W4

Rivets

**

11.12.29LocationLoc QtyLoc Code

ST321

2861

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

65

119883

1000

96

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

2.0000

1

6

D3065-041

Step Leg Assembly Hi

**

11.12.29LocationLoc QtyLoc Code

WA013

B77054

2

76193

2

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

Work Order ID: 77760

77760

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

D3067-1

Manufactured No

180

Each

67.0000

1

6

D3067-1

End Plate

**

11.12.29

Location

Loc Qty

Loc Code

WA016

67

67582

2

68214

1

76179

64

Purchased

No

250

Each

103.0000

**

12

Location

Loc Qty

Loc Code

ST353

103

119449

100

119641

3

Manufactured

No

250

Each

107.0000

**

12

Location

Loc Qty

Loc Code

ST481

107

73411

7

75547

100

Manufactured

No

250

Each

42.0000

**

6

D3278-041

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST481

42

76169

35

76170

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16

96

AN960.ID416

**

M119075

Washer
AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

24

AN960.ID516

**

M118206

Washer
AN5-36A Purchased

No

250

Each

105.0000

2

12

AN5-36A

**

SP

Bolt

Location

Loc Qty

Loc Code

ST340

105

119449

30

119641

75

Manufactured

No

250

Each

112.0000

2

12

D2618
D2618

**

SP

Bushing

Location

Loc Qty

Loc Code

ST019

112

74458

12

76130

100

Manufactured

No

250

Each

212.0000

4

24

D2230-3
D2230-3

**

12/1/14

Lug

Location

Loc Qty

Loc Code

ST480

212

53881

4

70973

1

75546

9

76642

198

24

December-21-11 9:03:07 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-21-11 9:03:07 AM

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Work Order ID: 77760

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

D2856-400

Manufactured No

250 f

200.2721 1.2

D2856-400

Abraison Strip

**

7.2

Location

Loc Qty

Loc Code

ST409

200.2721

63735

0.6696

68076

0.3149

71164

21.66

73491

177.6276

7.2

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased

No

250 Each

6,882.000

2

12

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

6882

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

838

12

AN4-13A

Purchased

No

250 Each

742.0000

8

48

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

742

118078

17

118838

125

119449

500

119798

100

7x

32 x

December-21-11 9:03:07 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 77760

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

77760

D350-591-311

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L5

Purchased

No

250

Each

2,130.000

12

12

MS21042I 5

Nut

**

Location

Loc Qty

Loc Code

ST300

2130

116105

5

116548

43

117611

52

118179

496

118910

34

119109

1500

MS21042L4

Purchased

No

250

Each

9,089.000

8

48

MS21042I 4

Nut

**

Location

Loc Qty

Loc Code

ST300

9089

117441

51

117601

342

118451

133

119017

3563

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

24

AN960.ID10

Washer

**

MI19537

12/4/11

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOWN
REFUS
ENGINEER
UNCONTROLLED COPY
SUBJECT TO IN. NUMBER

WITHOUT NOTICE
WORK ORDER
NO. 77760 *4-LJ*
11/12/21

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

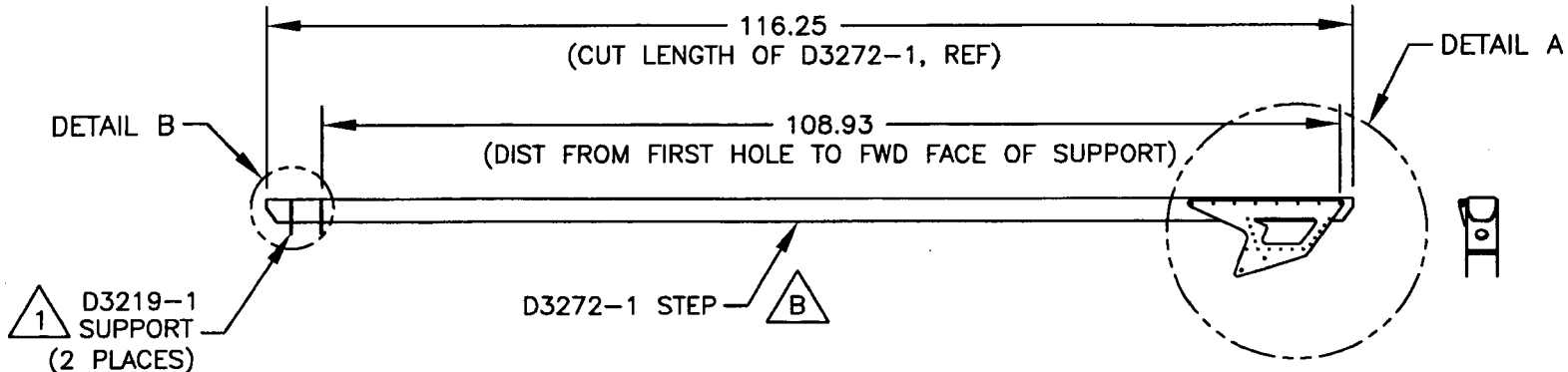
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

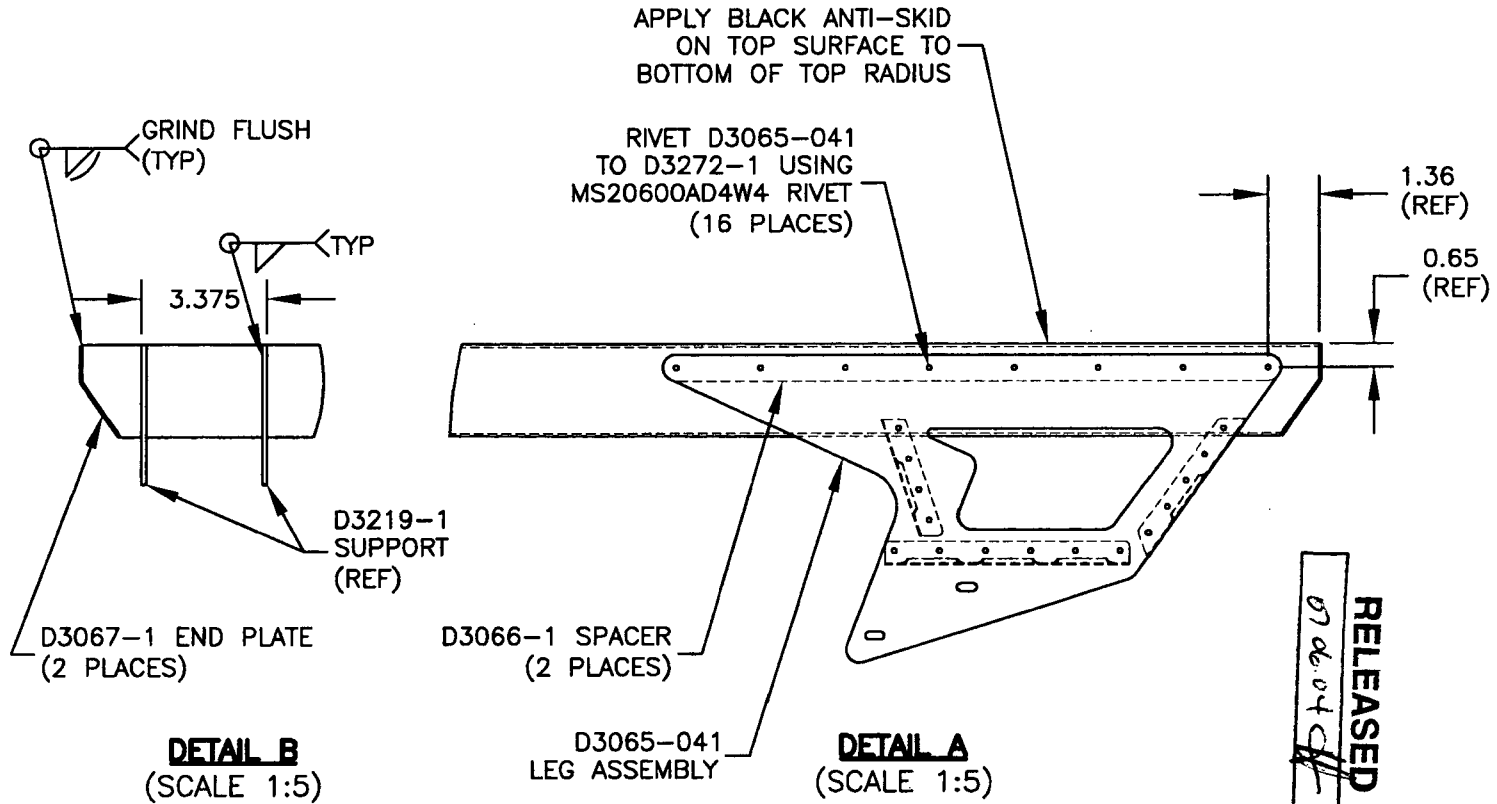
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77760



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

DESIGN	q	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED		REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
		STEP ASSEMBLY, HI LONG		SCALE 1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

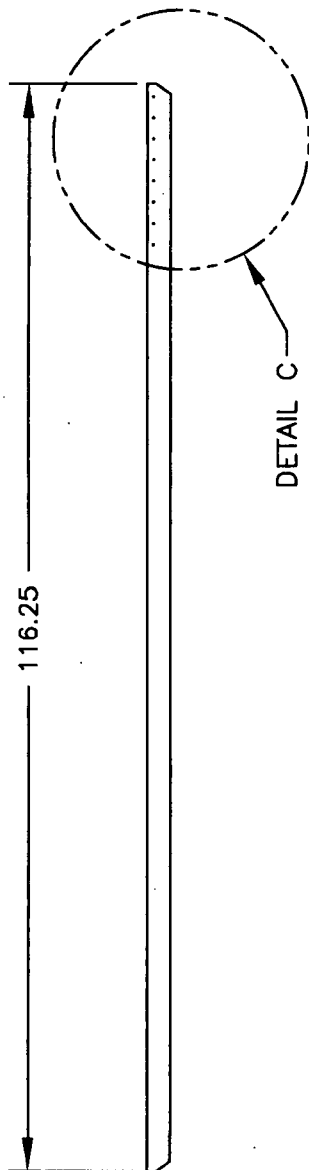
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

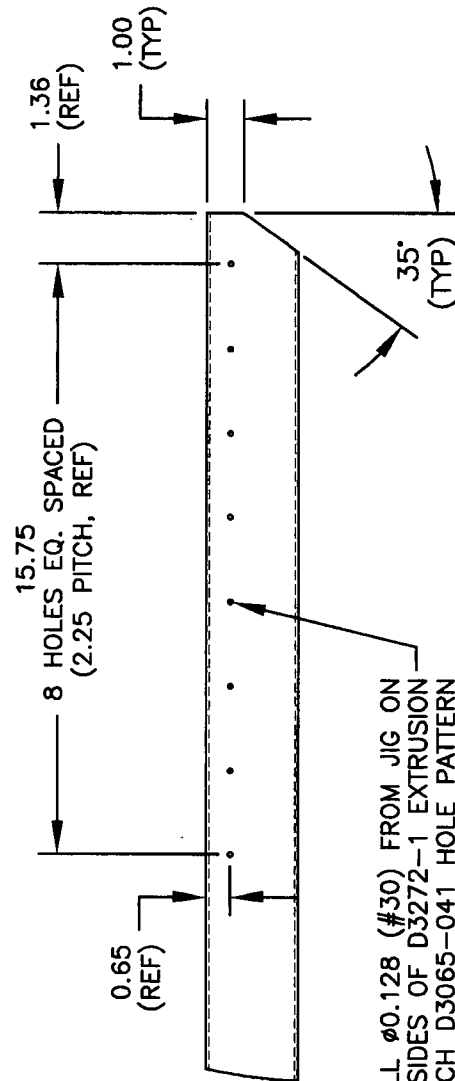


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.

D350-591

Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.